CLAIMS

1. A numerical control apparatus for controlling a drive unit for a machine tool making the processing by relatively moving a workpiece and a tool, comprising:

read skip signal input means for commanding to skip execution of instructions up to a desired instruction in a processing program;

read skip end instruction storing means for storing said desired instruction; and

read skip means for skipping the execution of instructions until the same instruction as said instruction stored in said read skip end instruction storing means is commanded, if a read skip signal is input by said read skip signal input means.

2. The numerical control apparatus according to claim 1, characterized by further comprising mandatory execution instruction storing means for storing an instruction to be necessarily executed even when the execution of said instructions is skipped, in which if a read skip signal is input by said read skip signal input means, said read skip means executes the same instruction as stored in said mandatory execution instruction storing means, when commanded in said processing program, after the instruction being executed in inputting said read skip signal up to commanding the same instruction as stored in said read skip end instruction storing means.

3. The numerical control apparatus according to claim 1 or 2, characterized in that said read skip means executes an instruction stored in said read skip end instruction storing means when reading said instruction.

4. The numerical control apparatus according to claim 3, characterized in that said read skip means judges whether or not to stop the block in the next block after the same instruction as stored in said read skip end instruction storing means is commanded, depending on the presence or absence of a block stop outside signal or a block stop parameter setting, and when said block stop outside signal or said block stop parameter setting is present, the block is stopped in the next block after the same instruction as stored in said read skip end instruction storing means is commanded.

5. The numerical control apparatus according to any one of claims 1 to 4, characterized in that said read skip means interrupts execution of the block being executed at present, if a read skip signal is input by said read skip signal input means.

6. The numerical control apparatus according to any one of claims 1 to 5, characterized in that said read skip means does not update the coordinate information while a read skip process is being performed, but updates only the modal information.

7. The numerical control apparatus according to any one

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of claims 1 to 6, characterized in that said read skip means is executed after executing a registered processing program if a read skip signal is input by said read skip signal input means.

8. The numerical control apparatus according to any one of claims 1 to 7, characterized in that said read skip end instruction storing means has an optional instruction set with a parameter.

9. The numerical control apparatus according to any one of claims 2 to 8, characterized in that said mandatory execution instruction storing means has an optional instruction set with a parameter.